

Date: Thursday, 3/2/2006 11:39:59 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER ASSEMBLY	
Job Number	: 26044		Part Number	: D3220041	
Estimate Number	: 10294		Drawing Number	: D3220 REV A1	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 3/2/2006	S.O. No. : N/A	Drawing Revision	: A1	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 3/9/2006	
Previous Run	: 24956B		Qty:	9	Um: Each
Written By	: SEE COMMENT Below				
Checked & Approved By	: SEE ABOVE USER & DATE				
Comment	: Est Rev:A New Issue 05-11-06 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S050	2024-T3 .050 sheet
 Comment: Qty.: 0.7266 sf(s)/Unit Total : 0.7266 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.050" thick (M2024T3S.050 Identify for D3220-1 Batch: _____		
2.0	SHEAR	SHEAR
 Comment: Cut blank: 14.250" x 7.000" grain along 14.250"		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
 Comment: HAAS CNC VERTICAL MACHINING #1 Machine D3220-1 as per Folio FA362 and Dwg D3220Stack of 5Identify as D3220-1		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
 Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK
 Comment: SECOND CHECK		
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
 Comment: SMALL & MEDIUM FAB RESOURCE 1		
1-Deburr		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/2/2006 11:39:59 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER ASSEMBLY

Job Number: 26044

Part Number: D3220041

Job Number:



Seq. #: Machine Or Operation:

Description :

2-C'sink D3220-1 as per Dwg D3220

SAD

06:03:02

9

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD

06:03:02

9

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0 MS20426AD34

RIVET



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 MS20426AD3-4 Rivet H15786

11.0 MS21059L4

Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS21059L4 Nutplate H19522

SAD 06:03:02 9

12.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3220-041 doubler as per Dwg D3220

SAD 06:03:02 9

13.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/03/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/2/2006 11:39:59 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER ASSEMBLY

Job Number: 26044

Part Number: D3220041

Job Number:



Seq. #: Machine Or Operation:

Description :

14.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 93

Lu 9/3/08 G

15.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/08

Job Completion



06-03-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/18/2006 4:04:08 PM.
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	DOUBLER ASSEMBLY		
Job Number	25552					
Estimate Number	10295					
P.O. Number						
This Issue	1/18/2006	S.O. No.	:	Part Number	D3220042	
Prsht Rev.	NC			Drawing Number	D3220 REV A1	
First Issue	1/1	Type	MACHINED PARTS	Project Number	N/A	
Previous Run	24956C			Drawing Revision	A1	
Written By				Material		
Checked & Approved By				Due Date	2/5/2006	Qty: 10 Um: Each
Comment	Est Rev:A New Issue 05-11-06 JLM					

Additional Product

Job Number:



REFERENCE ONLY

Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S050	2024-T3 .050 sheet	
		Comment: Qty.: 0.7266 sf(s)/Unit Total : 7.2660 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.050" thick (M2024T3S.050) Identify for D3220-2 Batch: M19053	
2.0	SHEAR	SHEAR	
		Comment: Cut blank: 14.250" x 7.000" grain along 14.250"	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine D3220-2 as per Folio FA362 and Dwg D3220 Stack of 5 Identify as D3220-2	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	

WORK ORDER CHANGES

N/O:

PROCEDURE CHANGE

By

Date

Qty

Approval
Chief Eng /
Prod MgrApproval
QC Inspector

DATE STEP

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-03-02	6	9 parts C sunk on wrong side. Part is now A now A -1		Create a w/o for 03220-041 QTY of 9	06-03-02	06-03-02		06-03-02

REFERENCE ONLY

NOTE: Date & initial all entries